

Claims:

1. A security panel (1), comprising an expanded metal mesh (2), the mesh having apertures (9) therethrough bounded by a plurality of sides (11), at least one of said apertures (9) having at least one side (11) to which is affixed a separate barbed structure (4), the barbed structure having at least one barb (14) extending in a plane of the panel (1) in towards another side (11) of said aperture (9).
2. A security panel (1) as claimed in Claim 1, in which said barbed structures (4) are affixed to all sides (11) of said at least one aperture (9).
3. A security panel (1) as claimed in Claim 1 or Claim 2, in which the barbed structure (4) has a plurality of said barbs (14) extending in the plane of the panel (1) in towards another side (11) of said aperture (9).
4. A security panel (1) as claimed in any preceding claim, in which the barbed structure (4) includes a plurality of barbed points (15,16,17) grouped in threes, a first (15) and a second one (16) of said barbed points extending in opposite directions parallel with the corresponding side (11) of said aperture (9), and the third one (17) of said barbed points extending transversely away from the corresponding side (11) of said aperture (9).
5. A security panel (1) as claimed in any preceding claim, in which said at least one barb (14) has a plurality of barbed points (15,16,17), each of said barbed points extending towards another side (11) of said aperture (9).

6. A security panel (1) as claimed in any preceding claim, in which each side (11) of an aperture (9) is formed from an elongate strip of metal (6), each of said strips of metal being joined integrally to adjacent strips of metal (6) at mesh nodes (8), the barbed structure (4) being affixed to just one corresponding strip of metal (6).

7. A security panel (1) as claimed in Claim 6, in which the barbed structure (4) is affixed to said one corresponding strip of metal (6) at one or more points lying between said mesh nodes (8).

8. A security panel (1) as claimed in Claim 6 or Claim 7, in which the barbed structure (4) lies entirely between mesh nodes (8).

9. A security panel (1) as claimed in any of Claims 6 to 8, in which the barbed structure (4) has a channel (12) with a complimentary shape to the corresponding strip of metal (6) to which the barbed structure (4) is affixed, the strip of metal (6) being seated in the channel (12) when the barbed structure (4) is affixed to the corresponding strip of metal (6).

10. A security panel (1) as claimed in Claim 9, in which the or each barb (14) has a corresponding base portion (18) that extends laterally away from said channel (12) in the plane of the panel (1).

11. A security panel (1) as claimed in Claim 10, in which the barbed structure (4) has at least one pair of said barbs (14) spaced along the length of the corresponding strip of metal (6) and extending in the plane of the panel (1) in

towards another side (11) of the same aperture (9), each one of said pair of barbs (14) having a base portion (18) that is distinct from base portions (18) of any adjacent barbs (14).

5 12. A security panel (1) as claimed in any of Claims 6 to 11, in which the barbed structure (4) has one or more tabs (24) which wrap around the corresponding strip of metal (6).

10 13. A security panel (1) as claimed in Claim 12, when appendant from Claim 10, in which said tab(s) (24) is/are provided between base portions (18) of an adjacent pair of barbs (14).

15 14. A security panel (1) as claimed in Claim 12 or Claim 13, in which the barbed structure (4) has at least one pair of said barbs (14) spaced along the length of the corresponding strip of metal (6), and at least one of said tabs (24) is positioned between said adjacent pair of barbs (14).

20 15. A security fence, comprising at least two upright fence supports (32), and a security panel (1), said security panel being supported by said fence supports (32), wherein the security panel (1) is as claimed in any preceding claim.

25 16. A method of forming a security panel (1), comprising the steps of: making a plurality of non-intersecting cuts in a sheet of metal; expanding the cut sheet to form an expanded metal mesh (2), the mesh having apertures (9) therethrough bounded by a plurality of sides (11); forming one or more
30 barbed structures (4) in metal separate from the expanded metal mesh (2), the or each barbed structure (4) having at least one extending barb (14); and affixing at least one of said barbed structures (4) to a side (11) of at least one of

said apertures (9) so that at least one barb (14) extends in a plane of the panel (1) in towards another side (11) of said aperture (9).

5 17. A method of forming a security panel (1) as claimed in Claim 16, in which the method comprises the step of affixing the or each barbed structure (4) between a pair of nodes (8) of the metal mesh (2).

10 18. A method of forming a security panel (1) as claimed in Claim 16 or Claim 17, in which the method comprises the steps of forming the barbed structure (4) with at least one extending tab (24), and then wrapping the or each tab (24) around portions of the metal mesh (2) bounding the aperture
15 (9) in order to affix the barbed structure (4) to said side (11) of said aperture (9).

19. A method of forming a security panel (1) as claimed in any of Claims 16 to 18, in which the method comprises the
20 step of welding the barbed structure (4) to the metal mesh (2) at one or more points between nodes (8) of the metal mesh (2).